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PERKINS S.F.

DART
AEROSPACE

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269T1338-11
Job Sheet 172247

Part No: 269T1338-11 **Job Qty:** 2 ea **DAS 21 9-89**

Part Name: Pitch Link Rigging Block

Part Weight: 0 lbs **Status:** Scheduled **Priority:** High

Job Created: 2/14/18 **Job Tracking No:**

Due Date: 4/30/18 **Created By:** Marie Lajeunesse

Type: SOLD **Description:**

Note: DWG 269T1338-11 Rev 4 IPP Rev A 18.02.12 New Issue FK Verify DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	4/30/18	0.00	0.00	Start Up Small Fab-4			
100	Small Fab	2 pcs	4/30/18	0.08	2.00	Small Fab-9			
110	QC	2 pcs	4/30/18	0.00	0.00	QC5			
130	Packaging	2 pcs	4/30/18	0.00	0.00	Packaging3-2			
140	QC21-FG	2 Ea	4/30/18	0.00	0.00	QC21			

Part Op 100 - 1- Assemble as per DWG sheet 1 2-When pressing -17 use machining fixture 269T1338-11 for -15. Make sure to
Descriptions: insert shim stock into gap to keep fixture from collapsing when pressing bushing.
130 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
CL-2-F	Ferrule	4 Ea (2 ea)	90-Start up Operation	5136060
269T1338-11-13	Block	2 Ea (1 ea)	100-Small Fab	5123053
269T1338-11-15	Locator	2 Ea (1 ea)	100-Small Fab	5122211
269T1338-11-25	T-Pin	4 Ea (2 ea)	100-Small Fab	5076400
8492A141	Drill Bushing	4 Ea (2 ea)	100-Small Fab	5047595
90945A761	Washer	4 Ea (2 ea)	100-Small Fab	5047616
91400A240	Machine Screw	2 Ea (1 ea)	100-Small Fab	5047596
92240A540	Hex Hdc Screw 1/4-20 X 3/4	4 Ea (2 ea)	100-Small Fab	5123586
98381A471	Dowel Pin	4 Ea (2 ea)	100-Small Fab	5047617
CL-.194-TERM	Lanyard Wire Eyelet	4 ft (2 ea)	100-Small Fab	5047526
CL-2-C	Lanyard Wire	2.6600 ft (1.33 ea)	100-Small Fab	5093863

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	CL-2-F	4	28	0
100-Small Fab	269T1338-11-13	2	0	0
	269T1338-11-15	2	0	0
	269T1338-11-25	4	0	0
	8492A141	4	4	0
	90945A761	4	100	0
	91400A240	2	50	0
	92240A540	4	50	0
	98381A471	4	100	0
	CL-.194-TERM	4	20	0
	CL-2-C	3	353	0

Part Specifications

Specifications could not be found.

Job BOM

32
79
79
79
61
66
50
53
41
32

Job BOM

CL-2-F
269T1338-11-13
269T1338-11-15
269T1338-11-25
8492A141
90945A761
91400A240
92240A540
98381A471
CL-.194-TERM
CL-2-C

Component Name

Ferrule
Block
Locator
T-Pin
Drill Bushing
Washer
Machine Screw
Hex Hdc Screw 1/4-20 X 3/4
Dowel Pin
Lanyard Wire Eyelet
Lanyard Wire

Quantity

4 Ea (2 ea)
2 Ea (1 ea)
2 Ea (1 ea)
4 Ea (2 ea)
4 Ea (2 ea)
4 Ea (2 ea)
2 Ea (1 ea)
4 Ea (2 ea)
4 Ea (2 ea)
4 ft (2 ea)
2.6600 ft (1.33 ea)

Operation

90-Start up Operation
100-Small Fab
100-Small Fab
100-Small Fab
100-Small Fab
100-Small Fab
100-Small Fab
100-Small Fab
100-Small Fab
100-Small Fab
100-Small Fab

Container

5136060
5123053
5122211
5076400
5047595
5047616
5047596
5123586
5047617
5047526
5093863

Job Allocations

90-Start up Operation
100-Small Fab

Component Part

CL-2-F
269T1338-11-13
269T1338-11-15
269T1338-11-25
8492A141
90945A761
91400A240
92240A540
98381A471
CL-.194-TERM
CL-2-C

Required

4
2
2
4
4
4
2
4
4
4
3

Inventory

28
0
0
0
4
100
50
50
100
20
353

Allocated

0
0
0
0
0
0
0
0
0
0
0

Part Specifications

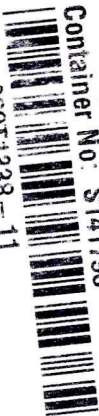
Specifications could not be found.

Plex 4/25/18 2:26 PM dart.logan.david

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Container No: S141793



Part: 2691338-11

Job No: 172247

Serial No/Batch: S141793

Revision: 4

Inspector:

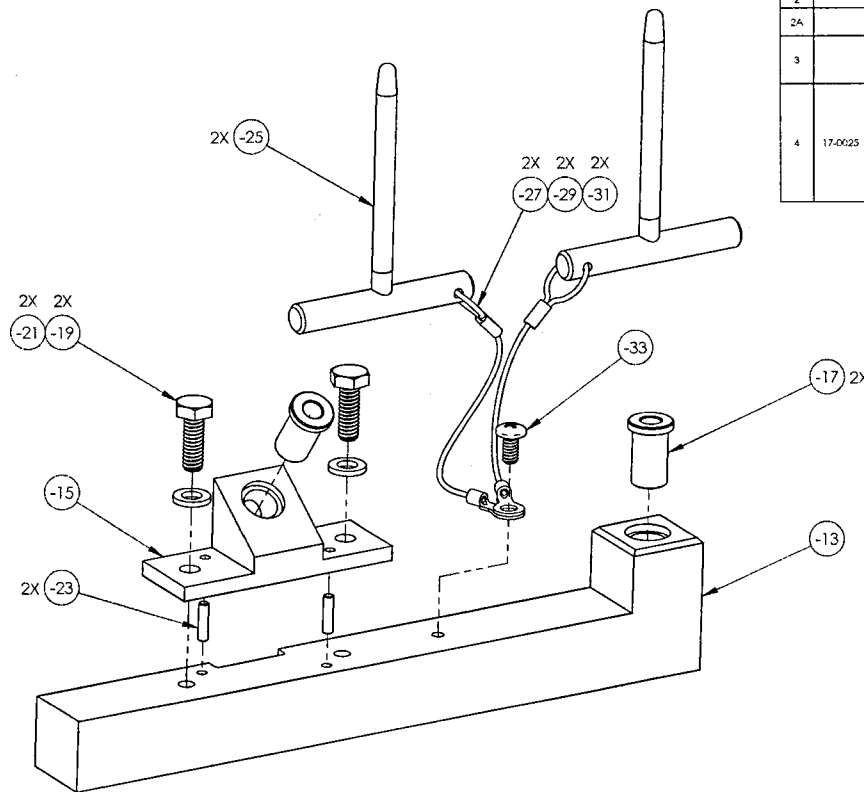
Exp Date:

Instructions:

Date: 01/04/19

85
02-9

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REVISIONS

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-15 LOCATOR HT., WAS 1.132.010, NOW 1.1051.005.	8/21/2009	WP	
1A		CHD P/N -23 FROM ROLL PIN PER W/P.	9/29/2009	RJC	WP
2		CHD -25 T-PIN FROM BUY OUT TO BEING MACHINED Ø.2490 TO Ø.2485 PER DAVE, ADDED PAGE 2.	11/12/2009	WP	RW
2A		CREATED SHEETS 3 & 4, MOVED COMPONENTS INTO SEPARATE SHEETS, REVISED BOM, ADDED NOTE 2, CHD -25 FINISH FROM BLACK OXIDE TO BLACK ZINC.	9/8/2011	SE	RW
3		-13 DELETED R.042 IN BOTTOM OF CUTOUT, ADDED MISSING DIM 2X P.06, CHD DIM WAS 2X Ø.125 P.F. -23 IS 2X LIMITS Ø.1244 TO .1249, -15 CHD DIM WAS 2X Ø.125 IS 2X LIMITS Ø.1255 TO .1258, -19 ADDED B/O INFO #9945A761, -23 ADDED B/O INFO #98381A471, -27 ADDED B/O INFO #3897131, -33 ADDED B/O INFO #97400A240, CHD TOLERANCE ON NON-CRITICAL PARTS.	5/22/2014	DPD	GE
4	17-0025	UPDATED TO NEW STANDARDS, DELETED NOTE 1 & 2, -13 CHD DIM WAS Ø.313 THRU L. J Ø.563 F. Ø.945 F. -17 Ø.4380/Ø.4375 F. Ø.94 F. -17 IS Ø.313 THRU ALL Ø.4380/Ø.4375 F. Ø.94 L. J Ø.563 F. Ø.945 F. -17 WAS 2X 1/4-20 UNC. THRU IS 2X 1/4-20 UNC. -28 THRU ALL WAS #10-24 UNC. F. Ø.3 B 10-24 UNC. -28 F. Ø.3, REMOVED DIM Ø.500, 1.125, 30, ADDED DIM Ø.500, .625, 1.500, .750, -18 CHD DIM WAS 500 IS 2X 500, WAS Ø.4380/Ø.4375 THRU P.F. -17 L. J Ø.563 F. Ø.945 F. -17 IS Ø.4380/Ø.4375 THRU P.F. -17 L. J Ø.563 F. Ø.94 IS F. -17, WAS 55 F. (35 F. REMOVED DIM 1.610), 175, .905, (405), -23 CHD MATERIAL WAS S.S. IS STEEL, -25 CHD DIM WAS 3.0 IS (3.0), CHD FINISH AND SPEC WAS BLACK ZINC ASTM B633-85, TYPE II, CLASS II B BLACK OXIDE QMSH 4.2.2, S.O. REV D. -27 CHD B/O INFO WAS 7-19 STRAND: Ø.0176 X 8 MCMASTER-CARR #893052 IS Ø.062 X 8 (CAPR-LANE CL-2-C), -28 CHD B/O INFO WAS Ø.0176 X 8 MCMASTER-CARR # 3897131 IS Ø.138 (CAPR-LANE # CL-2-F), -31 CHD B/O INFO WAS #10 IS #10 (CAPR-LANE # CL-194-TERM).	1/30/2017	SM	JAG

NOTE:
WHEN PRESSING -17 INTO -15 USE MACHINING
FIXTURE FOR -15. MAKE SURE TO INSERT SHIM
STOCK INTO GAP TO KEEP FIXTURE FROM
COLLAPSING WHEN PRESSING BUSHING.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	FG
			-13	1	BLOCK	6061		2
			-15	1	LOCATOR	6061		3
		B/O	-17	2	DRILL BUSHING	STEEL	Ø1/4 X 3/4 (MCMASTER-CARR # 8492A141)	1
		B/O	-19	2	HEX HEAD CAP SCREW	S.S.	1/4-20 X 3/4 (MCMASTER-CARR # 92240A540)	1
		B/O	-21	2	WASHER	S.S.	Ø1/4 I.D. (MCMASTER-CARR # 90945A761)	1
		B/O	-23	2	DOWEL PIN	STEEL	Ø1/8 X 1/2 (MCMASTER-CARR # 98381A471)	1
			-25	2	T-PIN	STEEL	Ø1/4 X 3 (MCMASTER-CARR # 98021A419) MODIFIED	4
		B/O	-27	2	COATED LANYARD CABLE	COATED STEEL	Ø.062 X 8 (CAPR-LANE CL-2-C)	1
		B/O	-29	2	FERRULE	METAL	ID.138 (CAPR-LANE # CL-2-F)	1
		B/O	-31	2	WIRE CRIMP EYELET	METAL	#10 (CAPR-LANE # CL-194-TERM)	1
		B/O	-33	1	MACHINE SCREW	S.S.	#10-24 X 3/8 (MCMASTER-CARR # 91400A240)	1



TITLE PITCH LINK RIGGING BLOCK ASSEMBLY

DWG NO.	269T1338-11	REV	4
MATL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		
FEAT	XXX ± .005 FRACTIONS ± 1/8		
FINISH	XX ± .01 ANGLES ± 5°		
SPEC	X ± .1 SURFACES ± 125/✓		
DRAWN BY:	PERRITT	1. BREAK ALL SHARP EDGES Ø.015 X 45° OR Ø.0158	
CHECKED:	RJC 02/01/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR:	RA 02/08/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
Q/A APPR:	JL 02/08/2017	USED ON MODEL	
APPROVED:	JAG 02/21/2017	SCHWEIZER, SEE NOTES	
SCALE	2:3	DATE	8/15/2007
		SHEET 1 OF 4	